

ship May 25 AOG

Work Order ID 147000

147000

Page 1

Wednesday, May 25, 2016 10:59:46 AM

Item ID: DSI 9723-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: PA100 PUREair System Upgrade

Start Date: 5/25/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/25/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: dm

Date: 16/05/25

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9723	A	<u>dm</u>							<u>MLS</u> MAY 25 2016
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							DAS 27 9-89
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP DSI9723-011 CHG001								
110	Pick Kit	0.00							
110									MAY 25 2016
Packaging	Memo	0.00							DAS 6 9-89
Packaging									DAS 28 9-89
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							DAS 27 9-89
Quality Control									

MAY 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							

Work Order ID 147000

Wednesday, May 25, 2016 10:59:46 AM

147000

Page 2

Item ID: DSI 9723-011

Accept

NS00040100Setup Start ***NS1***

Revision ID:

Item Name: PA100 PUREair System Upgrade

Stop ***NS2***

Start Date: 5/25/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/25/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP DSI9723-011
Location: 

1	DAS 27 9-89	DAS 28 9-89
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MAY 25 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

ML5	MAY 25 2016
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16-5-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 147000

147000

Parent Item: DSI 9723-011

DSI 9723-011

Parent Item Name: PA100 PUREair System Upgrade

Start Date: 5/25/2016

Required Date: 5/25/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.06.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Fast Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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650.0401		Purchased	No				Each	18.0000		1			
----------	--	-----------	----	--	--	--	------	---------	--	---	--	--	--

650 0401

PUREair Fairing Assembly

Location	Loc Qty	Loc Code
----------	---------	----------

FG109	18	
132155-1	18	
	Each	12.0000

AN821-12J		Purchased	No				Each	12.0000		1			
-----------	--	-----------	----	--	--	--	------	---------	--	---	--	--	--

AN821-12.J

Elbow (or AN821-12K or 12S)

Location	Loc Qty	Loc Code
----------	---------	----------

CCK004	12	
m134544	12	
	Each	940.0000

NAS1149D0332J		Purchased	No				Each	940.0000		58			
---------------	--	-----------	----	--	--	--	------	----------	--	----	--	--	--

NAS1149D0332.J

Washer

Location	Loc Qty	Loc Code
----------	---------	----------

CA	6	
m129682	6	
FP001	48	
m134502	48	
ST260a	600	
m134738	600	
ST264	286	
m134502	286	

DAS
27
9-89

MAY 25 2016

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 147000

147000

Part Item: DSI 9723-011

DSI 9723-011

Parent Item Name: PA100 PUREair System Upgrade

Start Date: 5/25/2016

Required Date: 5/25/2016

Start Qty: 1.00

Required Qty: 1.00

D4925-041	Manufactured	No		Each	2.0000	1			DAS 28 9-89
D4925-041									
Mounting Plate Assembly									
DAS 27 9-89			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST218	2					
			146178	2					
D4961-043	Manufactured	No		Each	0.0000	1			DAS 28 9-89
D4961-043									
Tube Assembly									
DAS 27 9-89									
D5179-1	Manufactured	No		Each	8.0000	2			DAS 28 9-89
D5179-1									
Doubler									
DAS 27 9-89			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST220	8					
			144643	8					
D5179-3	Manufactured	No		Each	12.0000	2			DAS 28 9-89
D5179-3									
Doubler									
DAS 27 9-89			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST220	12					
			144651	12					
D5194-1	Manufactured	No		Each	14.0000	2			DAS 28 9-89
D5194-1									
Doubler									
DAS 27 9-89			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST220	14					
			144649	14					

MAY 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Wednesday, May 25, 2016 10:59:53 AM

Work Order ID: 147000

147000

Parent Item: DSI 9723-011

DSI 9723-011

Parent Item Name: PA100 PUREair System Upgrade

Start Date: 5/25/2016

Required Date: 5/25/2016

Start Qty: 1.00

Required Qty: 1.00

D5208-041 Manufactured No

Each 7.0000 3

DAS
6
9-89

D5208-041

Blanking Plate Assembly

27
9-89

Location

Loc Qty

Loc Code

ST158

7

144641

7

Each

14.0000

DAS
6
9-89

EN3686-050016

Purchased No

EN3686-050016

Screw

DAS
27
9-89

Location

Loc Qty

Loc Code

ST559

14

m134586

14

Each

99.0000

DAS
6
9-89

LN29985-A05

Purchased No

LN29985-A05

Anchor Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

ST563

99

m133062

25

m134586

14

m134726

60

Each

124.0000

DAS
6
9-89

LN9038-05012

Purchased No

LN9038-05012

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

ST564

124

m134466

24

m134571

100

MAY 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

Wednesday, May 25, 2016 10:59:53 AM

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Work Order ID: 147000

147000

Parent Item: DSI 9723-011

DSI 9723-011

Parent Item Name: PA100 PUREair System Upgrade

Start Date: 5/25/2016

Required Date: 5/25/2016

Start Qty: 1.00

Required Qty: 1.00

LN9038-05018 Purchased No

Each 244.0000 56

! N9038-05018

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

ST564

244

M134571

44

M134586

200

**

DAS
6
28
9-89

LN9038-05040 Purchased No

Each 6.0000

! N9038-05040

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

ST564

6

m132423

2

m134466

4

**

DAS
6
28
9-89

LN9348-05 Purchased No

Each 114.0000

! N9348-05

Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

ST564

114

m134466

114

**

DAS
6
28
9-89

MS20426AD3-3 Purchased No

Each 2,340.000

MS20426AD3-3

RIVET

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

828

M131624

828

ST312

1512

M131624

1512

**

MAY 25 2016
DAS
6
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

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Wednesday, May 25, 2016 10:59:53 AM

Work Order ID: 147000

147000

Parent Item: DSI 9723-011

DSI 9723-011

Parent Item Name: PA100 PUREair System Upgrade

Start Date: 5/25/2016

Required Date: 5/25/2016

Start Qty: 1.00

Required Qty: 1.00

MS9592-138

Purchased

No

Each

17.0000

1

DAS 6 28
9-89 9-89

MS9592-138

Bracket

DAS
27
9-89

Location

Loc Qty

Loc Code

ST267

17

m132479

17

NAS43DD3-64

Purchased

No

Each

22.0000

1

DAS 6 28
9-89 9-89

NAS43DD3-64

Spacer

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

8

m132461

8

ST550

14

m134544

14

MAY 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART SERVICE INSTRUCTION

TO AMEND IIN-D350-822 REV. C/D
REF. TCCA STC: SH14-14
REF. ANAC STC: 2014S07-11

1.0 PURPOSE

THE PURPOSE OF THIS DSI IS TO PROVIDE AN UPGRADE KIT SO THAT CUSTOMERS WHO HAVE RECEIVED D350-822-011 @ CHG 001 (REF IIN-D350-822 REV. C) CAN UPGRADE THEIR KIT TO D350-822-011 @ CHG 002 (REF IIN-D350-822 REV. D) AND INSTALL THE KIT PER IIN-D350-822 REV. D.

2.0 CHANGE

THE DSI 9723-011 UPGRADE KIT IS DETAILED AS FOLLOWS:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9723-011	PA100 PUREAIR SYSTEM UPGRADE KIT
1	650.0401	PUREAIR FAIRING ASSY *
1	AN821-12J	ELBOW
58	BS4320-A5	WASHER (OR NAS1149D0332J)
1	D4925-041	MOUNTING PLATE ASSY *
1	D4961-043	TUBE ASSEMBLY
2	D5179-1	DOUBLER
2	D5179-3	DOUBLER
2	D5194-1	DOUBLER
3	D5208-041	BLANKING PLATE ASSY
2	EN3686-050016	SCREW
15	LN29985-A05	ANCHOR NUT
32	LN9038-05012	BOLT
56	LN9038-05018	BOLT
1	LN9038-05040	BOLT
26	LN9348-05	NUT
40	MS20426AD3-3	RIVET
1	MS9592-138	BRACKET
1	NAS43DD3-64	SPACER

* UPGRADE TO METRIC HARDWARE

3.0 WEIGHT AND BALANCE

This DSI has a negligible effect on Weight and Balance.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-C-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 15.05.29
CERT. NO.: SH14-14
ISSUE NO.: 1

A	NEW ISSUE	AK	15.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9723	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.		PA100 UPGRADE KIT	NTS
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REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND IIN-D350-822 REV. C/D

REF. TCCA STC: SH14-14

REF. ANAC STC: 2014S07-11

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